



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.9502
Job Sheet 166723-A



Part No: 646.9502

Job Qty: 1 ea

Part Name: 206A/B/L-Series Cable Cutter System, Low



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 10/26/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: L3 Army Fleet Support LLC (CARMY01)

Army Fleet Support Cairns Field Bldg 30300 Specker Street Fort Rucker, AL, 36362 USA ph:(334) 255-8373

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/26/17	0.00	0.00	Start up container	
110	Packaging	1 pcs	10/26/17	0.00	0.00	Packaging1	
120	QC	1 pcs	10/26/17	0.00	0.00	QC4	
125	DC	1 pcs	10/26/17	0.00	0.00	DC	
130	Packaging	1 pcs	10/26/17	0.00	0.00	Packaging3	
140	QC21-FG	1 Ea	10/26/17	0.00	0.00	QC21	

Part Op 125 - Photocopy bluefile & type labels per PPP 646.9502

Descriptions: 130 - Identify and pack for shipping as per PPP 646.9502 Location :FG101

21
8-89

NOV 21 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation 600-0990 600-0991 w.p. 1 feb 2018 5010069X2 600.1012 exp. 02/2018	600.0990 5010425	1	17	0	0
	600.0991 5010426	1	5	0	0
	✓ 600.1012 5010096	1	11	0	0
	✓ 646.9601 F165137	1	4	0	0
	✓ 646.9603 F160092	1	2	0	0
	✓ 646.9810 5010091	1	2	0	0
	✓ 646.9910 5010090	4	0	0	0
	✓ 647.0110 5010094	1	2	0	0
	✓ 647.0111 5010088	1	19	0	0
	✓ 647.0112 F161667X6	8	161	0	0
	✓ 647.0113 5010092	2	34	0	0
	✓ 647.0114 5010066	1	44	0	0
	✓ 647.0115 5010085	1	39	0	0
	✓ 647.0116 F165176	2	42	0	0
	✓ 647.0210 5010063	1	1	0	0
	✓ 647.0310 5010060	2	17	0	0
	✓ 647.0410 5010059	1	20	0	0
	✓ 647.1210 5010051	1	21	0	0
	✓ AN3-10A 5009579	8	38	0	0
	✓ AN3-11A 5009578	8	77	0	0
	✓ AN3-3A 5009577	1	96	0	0
	✓ AN743-13 5009574	1	27	0	0
	✓ CCR264SS-3-06 5009565	8	207	0	0
	✓ CCR264SS3-04 5009501	12	57	0	0
	✓ CCR264SS3-2 5009552	4	100	0	0

DQA: _____ Date: _____

WORK ORDER

QA Closed: _____ Date: _____



Work Order: _____	D'
Part No. _____	
NCR No. _____	
Date : _____	
Descr: _____	

Mfg Date: 11/16/17
Job No: 166723-A

646.9502
Start up operation

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkebury, ON K6A 1K7
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaero.com

Operation: _____
Revision: _____
Part No: _____
Change No: _____

Work Order update only ☐

DEPARTMENT/PROCESS

Water Jet	Engineering
Prod. Eng. Coord.	Quality
Pre/Packaging	Other
Supplier	

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure,	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Co	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐							
Misidentified	☐	Past Due	☐	OTHER :						

✓ CR3212-4-4	5009437	1	390	0	0
✓ CR3212-5-4	5009182	8	123	0	0
✓ CR3213-4-05	5009175	26	294	0	0
✓ CR3213-4-1	5009157	14	300	0	0
✓ CR3213-4-2	50090100	18	343	0	0
✓ CR3213-4-303 (16) K5T319	5009042	18	370	0	0
5009082x9 ✓ CR3213-4-404	5009080x10	19	250	0	0
✓ CR3213-4-6	5009075	20	397	0	0
✓ MS21042-08	5009071	54	0	0	0
✓ MS21042-3	5009056	17	0	0	0
5009541x2 ✓ MS21047-3	5009052x24	6	233	0	0
✓ MS21059-3	5009050	2	411	0	0
✓ MS21059L08	5009048	4	62	0	0
✓ MS24694-S8	5009047	5	185	0	0
✓ MS27039-08-06	5009029	4	25	0	0
✓ MS27039-08-09	5009027	4	148	0	0
✓ MS27039-08-11	5009021	43	1,598	0	0
✓ MS27039-08-12	5009020	2	696	0	0
✓ MS27039-08-13	5009018	6	191	0	0
✓ MS27039-1-08	5009014	5	515	0	0
✓ MS27039-1-11	5009013	5	240	0	0
✓ MS35842-11	5009009	1	39	0	0
✓ NAS1149F0332P	5009007	62	3,231	0	0
✓ NAS1149FN832P	5009003	111	4,525	0	0
✓ NAS1835-08	5009001	4	149	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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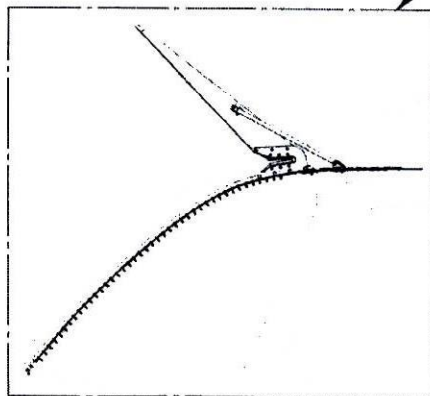
NOTES:

1 AFTER INSTALLATION, APPLY F/N 46 A/R TO FILL GAPS AND FILLET EDGES

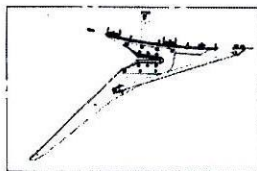
UNINCORPORATED ECN(S)

02729, 02736, 03047

DETAIL A



REFERENCE ONLY



DETAIL B

QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
1	1	49	601.1066 RIVET	CR3212-4-1	
1	1	48	600.0991 MAGNIBOND 6398 PART B		
1	1	47	600.0990 MAGNIBOND 6398 PART A		
1	1	46	600.1012 SEALANT	PP-1425 CLASS B	
5	5	45	601.1949 SCREW	MS27039-1-11	
2	2	44	601.2989 SCREW	MS27039-0812	
4	4	43	601.2987 SCREW	MS27039-0809	
4	4	42	601.3000 SCREW	MS27039-0806	

REV	DESCRIPTION	DATE	APPROVED
1	LAST PROPOSED REVISION P12		APC
2	INITIAL RELEASE	01/03/20	P. BRAYD

47	47	41	601.2893	SCREW	MS27039-0811	
1	1	40	601.2982	HOSE CLAMP	MS35842-11	
1	1	39	647.1210	SCREEN		
5	5	38	601.1621	SCREW	MS27039-1-08	
14	14	37	601.2979	RIVET	CR3213-4-1	
4	4	36	601.2984	INSERT	MS1835-08	
4	4	35	601.2277	RIVET	CCP2455-305	
8	8	34	601.2983	RIVET	CR3212-6-4	
12	12	33	601.2980	NUTPLATE RIVET	CCP2455-304	
1	1	32	601.2822	BOLT	AN3-3A	
1	1	31	601.2985	BRACKET	AN743-13	
2	2	30	601.1900	NUTPLATE	MS21059-3	
6	6	29	601.2988	SCREW	MS27039-0813	
53	53	28	601.2973	LOCKNUT	MS21042-08	
6	6	27	600.0795	NUTPLATE	MS21042-3	
18	18	26	601.0790	RIVET	CR3213-4-3	
18	18	25	601.1039	RIVET	CR3213-4-2	
19	19	24	601.1915	RIVET	CR3213-4-4	
20	20	23	601.2991	RIVET	CR3213-4-6	
26	26	22	601.1183	RIVET	CR3213-4-5	
4	4	21	601.2356	NUTPLATE	MS21059P08	
8	8	20	601.2981	NUTPLATE RIVET	CCP2455-306	
17	17	19	601.2943	LOCKNUT	MS21042-3	
16	16	18	601.2826	BOLT	AN3-11A	
46	46	17	601.1607	WASHER	MS1114P0325P	
114	114	16	601.2764	WASHER	MS1114P0323P	
1	1	15	647.0115	CLIP		
1	1	14	647.0114	CLIP		
1	1	13	647.0410	TUBE		
2	2	12	647.0116	DOUBLER		
1	1	11	647.0111	PANEL		
2	2	10	647.0113	STRUT DOUBLER		
8	8	9	647.0112	STRUT BRACKET		
4	4	8	646.9910	STRUT		
2	2	7	647.0310	CHANNEL		
1	1	6	647.0110	ROOF DOUBLER		
1	1	5	647.0210	RAIL		
1	1	4	646.9810	DEFLECTOR		
1	1	3	646.9603	LOWER CUTTER ASSY LOW		
1	1	2	646.9600	LOWER CUTTER ASSY HIGH		
1	1	1	646.9601	UPPER CUTTER ASSY		
			646.9502	206 CABLE CUTTERS FIF LOW		
			646.9501	206 CABLE CUTTERS FIF HIGH		

QTY	DESCRIPTION	MAT'L	SPEC.
1	ORIGINAL DATE		
1	DRAWN BY		
1	DESIGNED BY		
1	INSP. BY		
1	APPROVAL		
1	CONTRACT NO.		
1	UNLESS OTHERWISE SPECIFIED		
1	ALL DIMENSIONS ARE IN INCHES		
1	2 PLACE DECIMALS & 0.01		
1	3 PLACE DECIMALS & 0.001		
1	ANGLES & 5°		

APICAL INDUSTRIES

2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

206 CABLE CUTTERS KIT

REV. 07/26 DWO NO. 646.9500
SCALE NONE SHEET 1 OF 3

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02736			SHEET 1 OF 1	
	DWG NO. 646.9500	REV: N/C	PREPARED BY S. HUFF	DATE: 01/06/10	EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: 206 CABLE CUTTERS KIT				
	APPROVED BY:	ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: CORRECTED PARTS LIST ERRORS				

REFERENCE ONLY

17	R	601.1607	62	62	WASHER	NAS1149F0332P	
16	R	601.2764	111	111	WASHER	NAS1149FN832P	
			9502	9501			
F/N	TC	PART NUMBER	QTY	DESCRIPTION		MATERIAL/SPECIFICATION	
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM						☐ MAJOR ☒ MINOR	☐ YES ☒ NO

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO.		02729		SHEET 1 OF 3	
	DWG NO.	646.9500	REV: N/C	PREPARED BY	S. HUFF	DATE: 12/23/09
	DWG TITLE:		206 CABLE CUTTERS KIT			
	APPROVED BY:	ENGR <i>[Signature]</i>	MEG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: HARDWARE REVISIONS FROM FIRST INSTALL				

REFERENCE ONLY

51	A	601.3155	8	8	BOLT	AN3-10A
50	A	601.3153	5	5	SCREW	MS24694S8
41	R	601.2893	43	43	SCREW	MS27039-0811
28	R	601.2973	54	54	LOCKNUT	MS21042-08
18	R	601.2826	8	8	BOLT	AN3-11A
16	R	601.2764	127	127	WASHER	NAS1149FN832P
			9502	9501		
F/N	TC	PART NUMBER	QTY		DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: ☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM						CHANGE CATEGORY ☐ MAJOR ☒ MINOR
						DER REVIEW REQUIRED ☐ YES ☒ NO